

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017417**Date Inspected:** 13-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

ULTRASONIC TESTING**BAY # 11**

This QA Inspector performed Ultrasonic Testing (UT) of West Tower Lift 5 grillage welds D-E corner weld WSD1-T15-4B-F-7, 36. UT was performed on the compression area as in accordance with AWS D1.5-2002, section 6, table 6.4. No any rejectable indications were observed at the time of testing.

BAY # 14

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 022 located at PCMK AP3010-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044801 performing the Flux Cored Arc

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Welding process on weld 084 located at PCMK AP3005-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201981 performing the Flux Cored Arc Welding process on weld 024 located at PCMK SEG3013AD. ABF QA Mr. Shao Jian Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-u2-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 200113 performing the Shielded Metal Arc Welding process on weld 011 located at PCMK SEG3011A. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F) Repair-1.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing Ultrasonic testing for the weld SEG3014A-007.

This Quality Assurance (QA) Inspector observed ABF personnel performing Ultrasonic testing for the weld OBE13C-002.

BAY # 16

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068994 performing the Flux cored Arc Welding process on weld 019 located at PCMK W5-SB1-014. ZPMC QC Mr. Guo Pan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-u2-f.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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